

Date: Monday, 1/7/2008 3:38:43 PM  
User: Kim Johnston

*ASAP*

**Process Sheet**

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPAD
Job Number	: 36637		
Estimate Number	: 12784		
P.O. Number	:	Part Number	: D35649
This Issue	: 1/7/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3564 REV D
First Issue	: 1/1	Project Number	: N/A
Previous Run	: 36023	Drawing Revision	: D
		Material	:
		Due Date	: 1/21/2008
Written By	:	Qty:	20 Um: Each
Checked & Approved By	: <i>[Signature]</i> 08.01.8		
Comment	: Est Rev: A New Issue 07-03-08 ec Est Rev: B As per Rev C 07-07-09 JLM Est Rev: C As per Rev D 07-09-09 JLM Verified By: EC		

**Additional Product**

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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*25.41*



Comment: Qty.: 1.1550 sf(s)/Unit Total : 23.1000 sf(s)  
M304S16GA Stainless steel sheet 0.063" thick  
Batch: *106653 B 8-1-10*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
1-Cut as per Dwg D3564 \*\*\*\*\* (D3564-1F) \*\*\*\*\*  
Dwg Rev: *D* *B 8-1-10*  
Prog Rev: *D*  
  
2-Deburr if necessary *B 8-1-10*

*(22)*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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*B 8-1-10*



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*08/01/11 (22)*

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE  
Deburr if necessary  
Form on Brake as per Dwg D3564 using Jigs DT *8155* and DT *8179*  
  
Form Joggle as per Dwg D3564 on brake using Jig DT *8157*

*DB 08/01/17 22*

*CP 08/01/17 (22)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/7/2008 3:38:43 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 36637

Part Number: D35649

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

08/01/18 (422)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description

Batch

A/R 2059B Hardcoat

Weld hardcoat as per Dwg D3437

M106834  
M106390

FC 08/01/22 (22)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-01-22 (22)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-01-22 (22)

10.0

POWDER COATING

POWDER COATING



M106442



(22X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M-1 08/01/24

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HL



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-01-25

(422)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: F-P 18

M-1 08/01/25

(22X)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.01.25

Job Completion



08/01/25

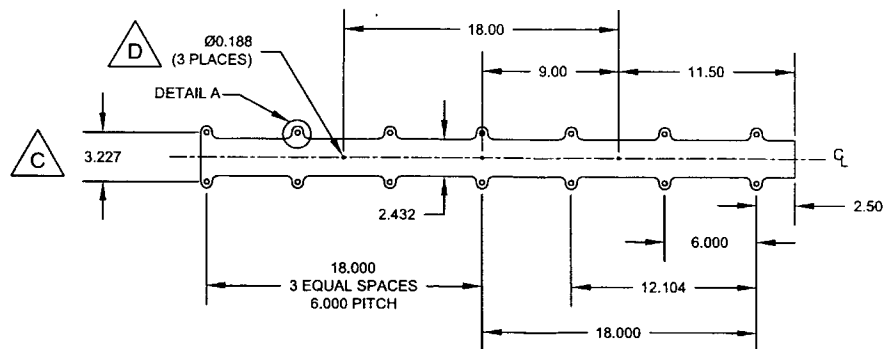
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

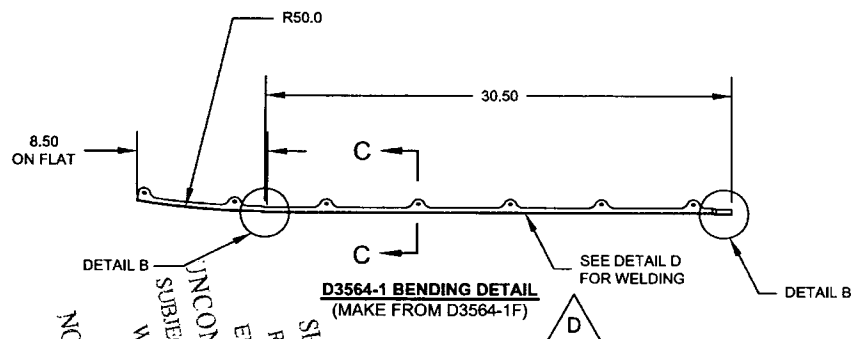
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

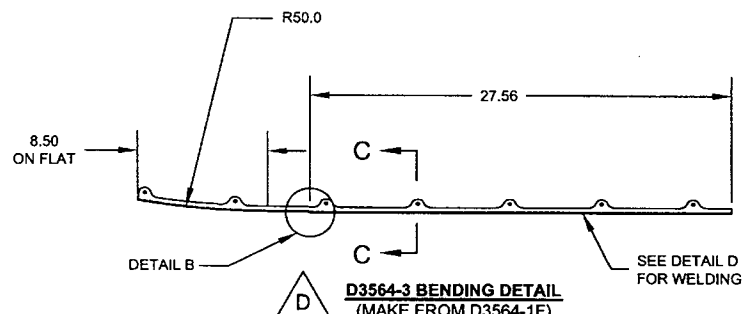
NOTE: Date & initial all entries



**D3564-1F FLAT PATTERN**



**D3564-1 BENDING DETAIL**  
(MAKE FROM D3564-1F)



**D3564-3 BENDING DETAIL**  
(MAKE FROM D3564-1F)

**D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT  $\bar{C}$

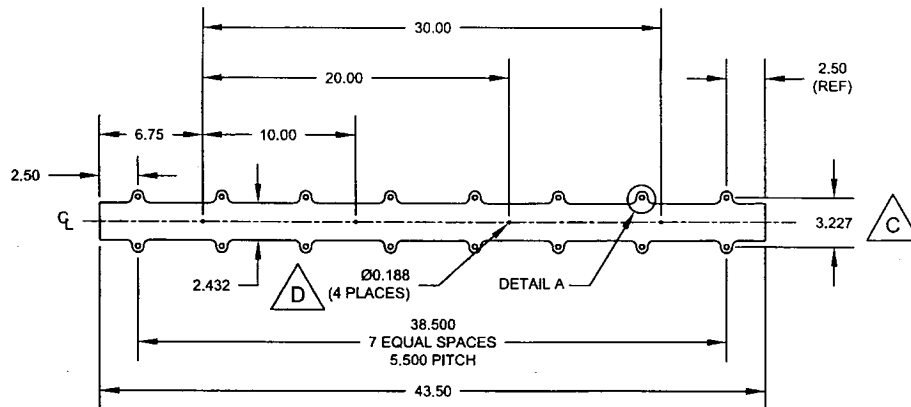
WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

**RELEASED**

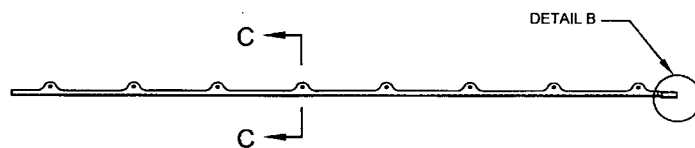
07.09.04

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 1 OF 3
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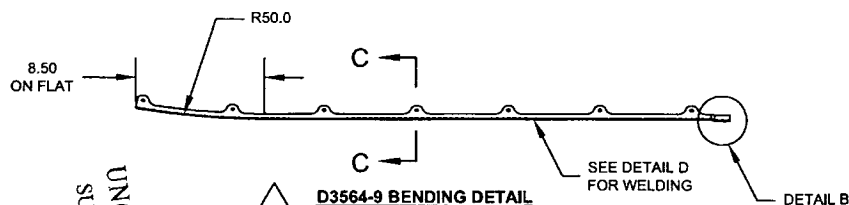
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**D3564-5F FLAT PATTERN**

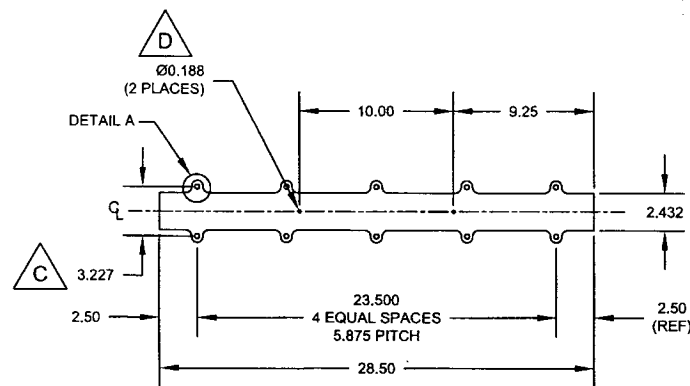


**D3564-5 BENDING DETAIL**  
(MAKE D3564-5 FROM D3564-5F)

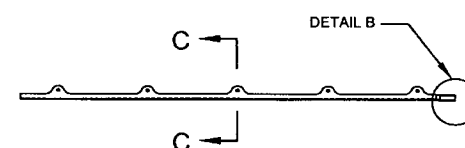


**D3564-9 BENDING DETAIL**  
(MAKE FROM D3564-1F)

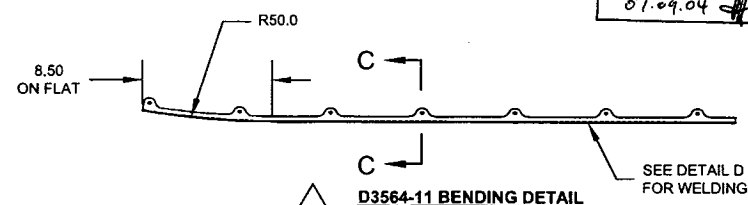
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**D3564-7F FLAT PATTERN**



**D3564-7 BENDING DETAIL**  
(MAKE D3564-7 FROM D3564-7F)

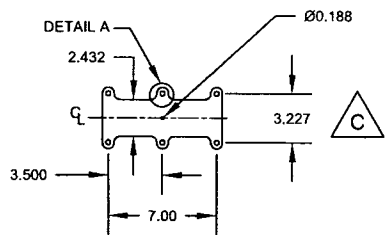


**D3564-11 BENDING DETAIL**  
(MAKE FROM D3564-1F)

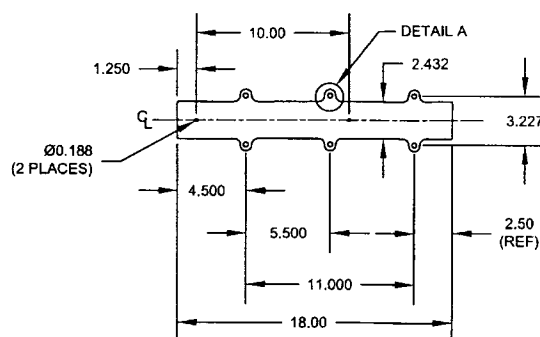
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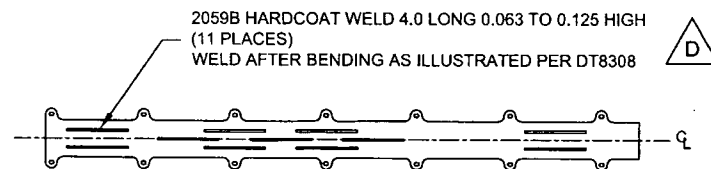
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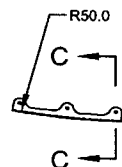
**D3564-13F FLAT PATTERN**



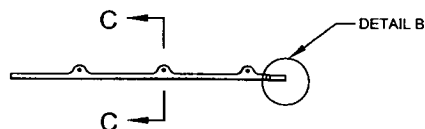
**D3564-15F FLAT PATTERN**



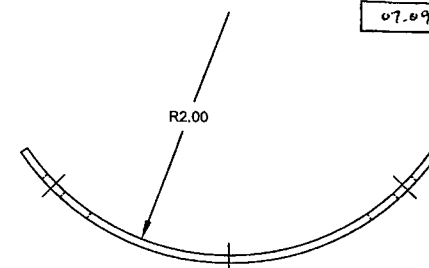
**DETAIL D**  
(D3564-1/-3/-9/-11 WELDING DETAIL)



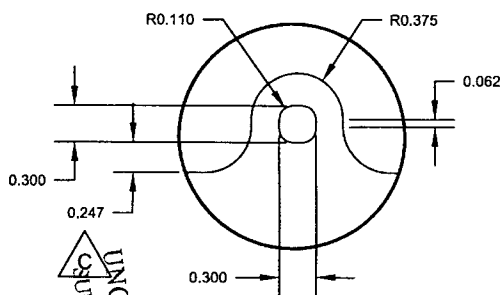
**D3564-13 BENDING DETAIL**  
(MAKE D3564-13 FROM D3564-13F)



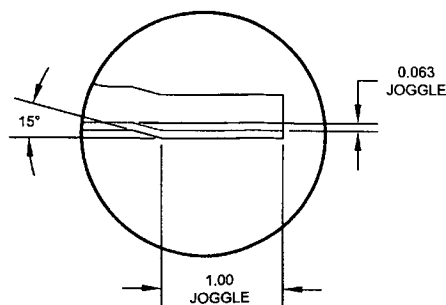
**D3564-15 BENDING DETAIL**  
(MAKE D3564-15 FROM D3564-15F)



**SECTION C-C**  
SCALE 1:1



**DETAIL A**  
SCALE 1:1



**DETAIL B**  
SCALE 1:1

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CHECKED	PH	DRAWING NO. D3564	REV. D
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